

161944

Tuesday, May 23, 2017 11:03:40 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/1/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/9/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: MAY 24 2017

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: 3-89 Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 161944

Tuesday, May 23, 2017 11:03:40 AM

161944

Page 2

Item ID: D350-749-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Low to High Gear Conversion

Start Date: 6/1/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/9/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-749-015 Location : FG121 PPP Rev: _____ "NO DART ARC OR C OF C REQUIRED" **ATTN: ALL ORIGINAL EUROCOPTER ARC AND TAGS TO BE SHIPPED WITH KIT**								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS DAS
28 27
JUN 06 2017

17/6/7

JUN 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Tuesday, May 23, 2017 11:03:39 AM

Page 1

Required Qty: 1.00

DAS
28
9-88

DAS
28
9-89

DAS
28
9-89

DAS
28
9-86

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Tuesday, May 23, 2017 11:03:39 AM

Page 2

Work Order ID: 161944

161944

Parent Item: D350-749-015

D350-749-015

Parent Item Name: Low to High Gear Conversion

Start Date: 6/1/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

22201TK080018X

Purchased

No

110

Each

4.0000

2

2

22201TK080018X

SCREW

**

CWB

JUN 05 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST577

4

m135585

2

m137503

2

2

23112TK080X

Purchased

No

110

Each

2.0000

2

2

23112TK080X

WASHER

**

CWB

JUN 05 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST578

2

m136136

2

2

ASN52320BH120N

Purchased

No

110

Each

13.0000

2

2

ASN52320BH120N

NUT

**

CWB

JUN 05 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST556

13

121159

3

m135585

10

2

22201TK060070X

Purchased

No

110

Each

4.0000

2

2

22201TK060070X

SCREW

**

CWB

JUN 05 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST578

4

m135585

2

m137503

2

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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REFERENCE ONLY

Qty -011	Qty -013	Qty -016	Qty -021	Qty -023	Qty -031	Qty -033	Part Number	Description
X							D350-748-011	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE
	X						D350-748-013	LANDING GEAR KIT HIGH, AIRCRUISER / DART TRI-BAG FLOAT COMPATIBLE
		X					D350-748-016	STANDARD TO HIGH GEAR CONVERSION KIT
			X				D350-748-021	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE W/ RUN-ON LANDING WEARPLATE
				X			D350-748-023	LANDING GEAR KIT HIGH, AIRCRUISER / DART TRI-BAG FLOAT COMPATIBLE W/ RUN-ON LANDING WEARPLATE
					X		D350-748-031	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE W/ DELUXE SKIDTUBES
						X	D350-748-033	LANDING GEAR KIT HIGH, AIRCRUISER / DART TRI-BAG FLOAT COMPATIBLE W/ DELUXE SKIDTUBES
1	1		1	1	1	1	D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
1	1		1	1	1	1	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1							D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
1							D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
	1						D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE
	1						D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE
			1				D350-636-015	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
			1				D350-636-016	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
				1			D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
				1			D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
					1		D350-636-215	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE DELUXE
					1		D350-636-216	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE DELUXE
						1	D350-636-217	SKIDTUBE INSTALLATION, LH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE DELUXE
						1	D350-636-218	SKIDTUBE INSTALLATION, RH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE DELUXE
		4					350A41-1088-20	STRIP, CHAFING, UPPER
		2					350A41-1090-20	STRIP, CHAFING, LOWER, FRONT
		2					350A41-1089-20	STRIP, CHAFING, LOWER, REAR
		4					350A41-1082-22	HALF, CLAMP
		2					22201TK080018X	SCREW
		2					23112TK080X	WASHER
		2					ASNS23208H120N	NUT
		2					22201TK080070X	SCREW

*ADDITIONAL PARTS ARE REQUIRED WHEN SWITCHING FROM STANDARD TO HIGH GEAR ON AS350/355 AIRCRAFT. CUSTOMERS WHO ARE SWITCHING FROM STANDARD TO HIGH GEAR CAN PROCURE THE D350-748-015 CONVERSION KIT.

D	ADD -111/-113/-121/-123/-131/-133	CP	15.05.28
C	ADD -021/-023/-031/-033 KITS	RF	11.09.28
B	ADD D350-748-015 KIT FOR STANDARD TO HIGH GEAR CONVERSION	PH	08.02.08
A	NEW ISSUE	CP	08.09.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED	AP		
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	15.05.28		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D350-749	REV. D SHEET 1 OF 2
TITLE LANDING GEAR KITS	SCALE NTS
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Work Order ID 161944

Tuesday, May 23, 2017 11:03:40 AM

161944

Page 1

Item ID: D350-749-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Low to High Gear Conversion

Stop ***NS2***

Start Date: 6/1/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/9/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: **MAY 24 2017**

Tooling: _____ Date: _____

Run Start ***NR1***QC: 3-80 Date: _____ SPC (Y/N): _____ Date: _____Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D350-749	D
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JUN 01 2017**DAS 6**

100

Document Control

90.00***100***

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP350-749-015 CHG 001
"NO DART ARC OR C OF C REQUIRED"

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

CNR**JUN 05 2017****DAS 4**

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS 28
9-38**JUN 06 2017**